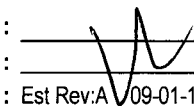
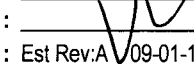
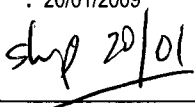


Date: Monday, 19/01/2009 8:34:33 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BUSHING
<b>Job Number</b> : 44879	
<b>Estimate Number</b> : 13732	
<b>P.O. Number</b> :	<b>Part Number</b> : D26171
<b>This Issue</b> : 19/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2617 REV D2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D2
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 20/01/2009
<b>Checked &amp; Approved By</b> : 	<b>Qty:</b> 20 <b>Um:</b> Each
<b>Comment</b> : Est Rev:A 09-01-19 rev.D2 as per dwg DD verified by:EC 	

## Additional Product


Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W
-----	------------------	-----------------------------



**Comment:** Qty.: 0.1641 f(s)/Unit Total: 0.1641 f(s)  
 6061-T6 Round Bar 1.5"  
 Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)  
 Ø0.375" tubing x 0.058" wall  
 (M6061T6T0.375W.058) Batch: M110271  09/01/19 (20)

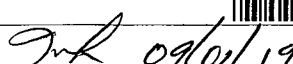
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



**Comment:** HARDINGE  
 Turn as per Folio FA796 and Dwg D2617  09/01/19 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE  09/01/19 (20)

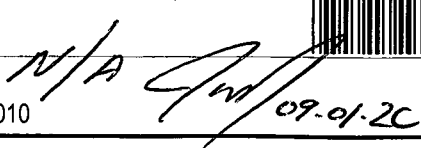
4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK  09/01/19 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr break all unmarked sharp edges 0.005 to 0.010  09-01-20

Date: Monday, 19/01/2009 8:34:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 44879

Part Number: D26171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*n/a 12/09-01-20*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

*HD 09-01-20 (20)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FD 09/01/20 (20)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5138*

*Reg 09-01-20 (20)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/20*

Job Completion



*MF 09-01-20*

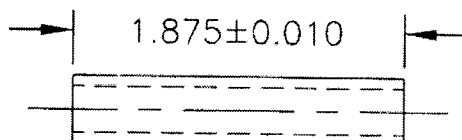




DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. 0 SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING SCALE 1:1			
A		96.10.08	NEW ISSUE		
B		97.05.08	.875 WAS 1.125		
C		97.06.04	0.369 DIA WAS 0.375		
D		01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE		
D1		CP	04.07.12	CORRECT TOLERANCE (NCR 779)	

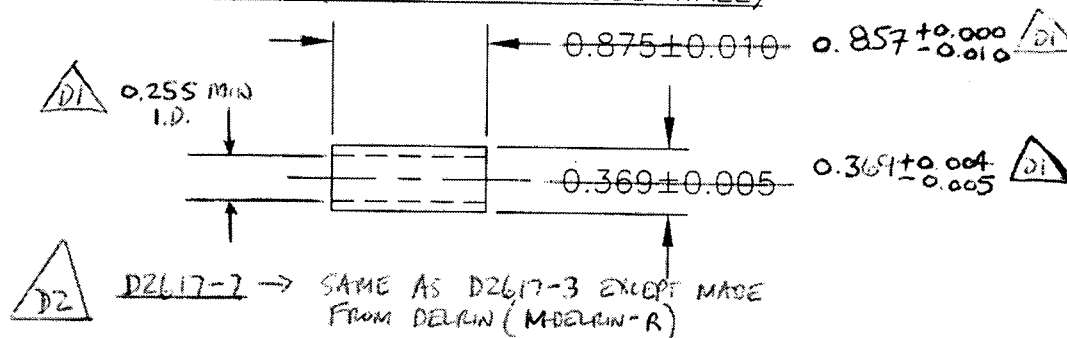
DZ 04.09.10 #/CP ADD D2617-7

D2617-1 (0.375 OD x 0.058 WALL)

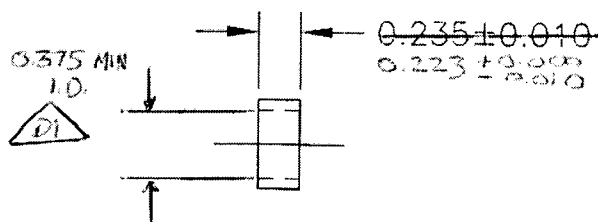


W.D. 8/79

D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #/CP

#### NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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